

Blue

Date: Wednesday, 03/09/2008 10:25:52 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE		
Job Number	: 41715		Part Number	: D29391		
Estimate Number	: 10836		Drawing Number	: D2939 REV C - BLUE		
P.O. Number	:		Project Number	: N/A		
This Issue	: 03/09/2008		Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 26/09/2008		
Previous Run	: 40283		Qty:	3 Um: Each		
Written By	:					
Checked & Approved By	: <u>JUL 089.03</u>					
Comment	: Est: B00.06.26 New DWG rev (mpp 2069) EC					
	Est Rev:C As per Rev C 07-03-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: <u>34823</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 5-Deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:25:52 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 08/09/12 (3)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

ff

08 - 09 - (5) (X3)

7.0 SPRAY PAINTING SPRAY PAINTING



Comment:

-PRIME

B106729

-SPRAY PAINT DELFLEET BLUE

B105918

-CLEAR DELFLEET

B109333

ml 08 09 23

(3)

8.0 QC14 INSPECT SPRAY PAINT



INSPECT SPRAY PAINT

ff 08-09-25

Comment: INSPECT SPRAY PAINT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



(3x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 405

8/9/25

SP

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/09/26 ff

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 0809-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

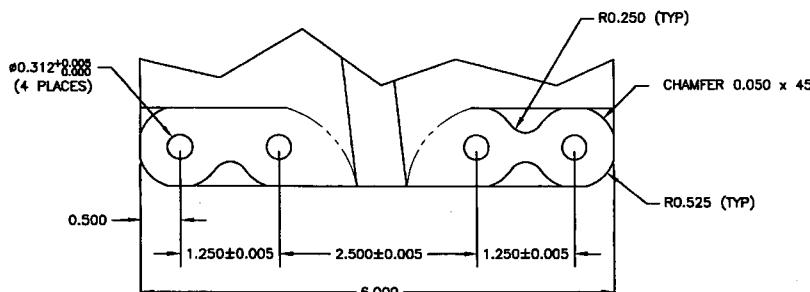
DART AEROSPACE LTD			Work Order: 41715
Description: 206 Saddle, Inboard, Left side			Part Number: D2939-1
Inspection Dwg: D2939 Rev. C			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.130	.130	.130			
B	0.100	0.140		.130	.130	.130			
C	0.100	0.140		.115	.115	.115			
D	0.210	0.230		.225	.227	.225			
E	1.245	1.255		1.246	1.250	1.250			
F	1.245	1.255		1.249	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.510	.510	.510			
I	1.572	1.582		1.578	1.578	1.578			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		.258	.258	.258			
L	0.312	0.317		.314	.314	.314			
M	0.235	0.240		.238	.237	.238			
N	0.100	0.140		.111	.112	.112			
O	0.540	0.560		.550	.550	.552			
P	0.490	0.510		.504	.504	.502			
Q	3.715	3.725		3.720	3.720	3.720			
R	2.720	2.760		2.742	2.742	2.742			
S	0.240	0.270		.258	.258	.258			
T	0.100	0.180		.140	.140	.140			
U	1.625	1.635		1.628	1.628	1.628			
V	1.362	1.372		1.367	1.367	1.367			
W	0.316	0.321		.320	.320	.320			
X	1.250	1.270		1.260	1.260	1.260			
Y	1.565	1.585	DT8695 A/B	1.580	1.580	1.580			
Z	0.178	0.198		.184	.184	.184			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>J.F.</i>	Audited by:	<i>J.F.</i>
Date:	<i>08/09/12</i>	Date:	<i>08/09/12</i>

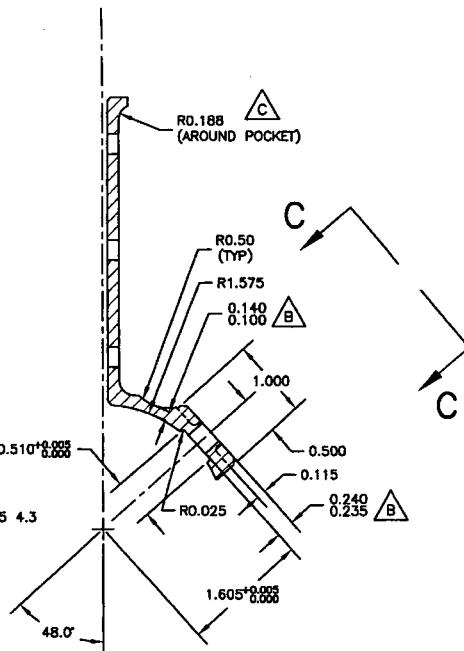
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>✓</i>	<i>J.F.</i>



VIEW C-C

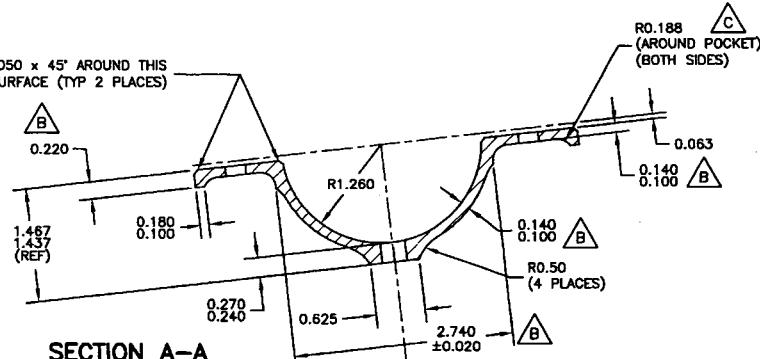
D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:
 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE INCHES
 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

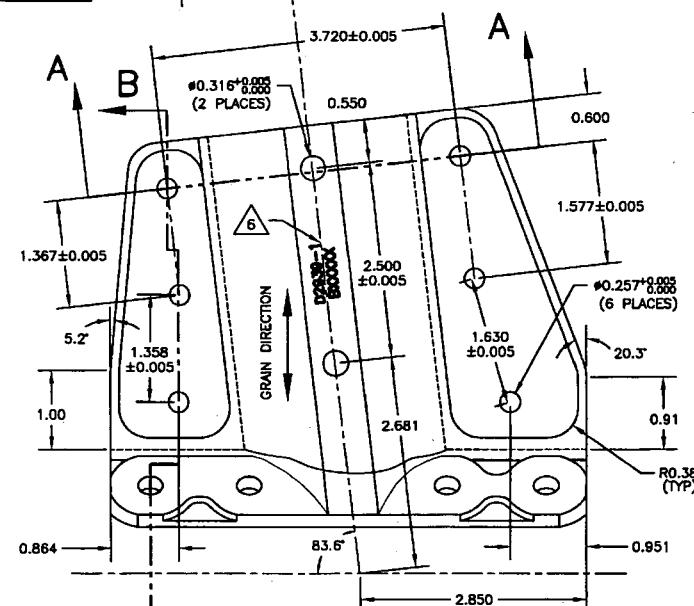


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2939
PH	CB	REV. C
DATE	06.11.09	SHEET 1 OF 1
		SCALE 2:5
		TITLE SADDLE INSIDE

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